Work Order ID 51510

August 25, 2009 1:34:21 PM

Item ID: D205-634-041
Revision ID: D
Item Name: Replacement Skidtube

Start Date: 8/24/09 **Start Qty:** 1.00
Required Date: 8/24/09 **Req'd Qty:** 1.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** [signature] **Date:** 09-8-25 **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Draw Nbr	Revision Nbr
D2580	Rev D

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	DOCUMENT CONTROL	0.00							
DC	**Memo**	0.00							
Document Control	Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002								
110	BENDING MACHINE - SKIDTUBES	0.00							
CNC Bend 1	**Memo**	0.00							
CNC Delta 100 Bender	1-Bend as per program D2580.C on CNC Bender and Folio FT009 2-Cut tubes as per Dwg. D2580								

PRO →

SCRAP

MB 09-09-02

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: D205-634-041 **PAR #:** _____ **Fault Category:** skid tubes **NCR:** (Yes) No **DQA:** _____ **Date:** 05.10.20

Resolution: Scrap **Disposition:** Scrap **QA: N/C Closed:** _____ **Date:** 05.10.20

NCR: 5510		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B **Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
9/9/8	110	During inspection found that Aft Bend on the skid tube is bent 120 low. Should be 1.400" high, but only measures 0.875" about.		AFT CUT ALSO NOT PERPENDICULAR SCRAP TUBE 09.09.23	BE 09/10/08	DP MP 09-10-08		09.10.08
		R.C. Process/LOA for cutting the tube prior to ver. fixing on the table.	09/10/08					

NOTE: Date & initial all entries

Work Order ID 51510

August 25, 2009 1:34:21 PM

Item ID: D205-634-041 **Accept** **Setup Start**

Revision ID: D **Stop**

Item Name: Replacement Skidtube

Start Date: 8/24/09 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 8/24/09 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00				1	Ø	-	AWM 9-9-8
Skidtubes	**Memo**	0.00							
Skidtubes	1- Deburr ends								
	2- C'sink holes as per dwg without cutting fluid								
	3- Prepare tube for welding, remove alodine as required.								
	4- Scribe batch number insied aft end of tube.								
130	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

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Cust Item ID:
Customer:

Accept **Setup Start** **Stop** **Run Start** **Stop**

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		0.00							
Skidtubes	**Memo**	0.00							
Skidtubes									

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R[illegible] Aluminum Rod _____

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.
For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R[illegible] Aluminum Rod _____

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web.Deburr

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

6-Drill pilot holes for aft cap using DT 8215Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640"and Deburr

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Reference:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:** **Run Start** **Stop**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC10- Inspect visual per QSI004- ground welds	0.00							
QC	**Memo**	0.00							
Quality Control									
160	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									
170	Pressure Wash per QSI005 4.3	0.00							
HandFinish	**Memo**	0.00							
Hand Finishing									

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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Item Name: Replacement Skidtube

Start Date: 8/24/09 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 8/24/09 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	**Memo**	0.00							
Powder Coating	START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____								
190	QC3- Inspect Part Finish	0.00							
QC	**Memo**	0.00							
Quality Control									

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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Item Name: Replacement Skidtube

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Required Date: 8/24/09 **Req'd Qty:** 1.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200		0.00							
HandFinish		0.00							
Hand Finishing									

Memo

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R Sikaflex-291 _____
Sikaflex expire date: _____

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R Sikaflex-291 _____
Sikaflex expire date: _____

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: _____

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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Work Order ID 51510

August 25, 2009 1:34:21 PM

Item ID: D205-634-041 **Accept** **Setup Start** **Stop**

Revision ID: D

Item Name: Replacement Skidtube

Start Date: 8/24/09 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 8/24/09 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control	Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024								
220		0.00							
Packaging	Packaging								
Packaging	**Memo**	0.00							
	Identify and pack for shipping as per PPPD205-634-041 Location:_____ PPP Rev:_____								
230	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

W 9.10.16

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

August 25, 2009 1:34:20 PM

Work Order ID: 51510

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/24/09 **Required Date:** 8/24/09

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2580-1RevD		Manufactured	No			110	Each	14.0000	1.0000			
205 Skidtube bent detail												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
LG	13		_____
50757	3		_____
50761	6		_____
50976	2		_____
50977	2		_____
Main Warehouse			
ST	1		_____
50758	1		_____

B51743
DP
9-9-2

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2576-3RevG		Manufactured	No			140	Each	141.0000	1.0000			
Step (maching detail)												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	141		_____
43504	40		_____
46661	101		_____

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

Picklist Print

August 25, 2009 1:34:20 PM

Work Order ID: 51510

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Start Date: 8/24/09 **Required Date:** 8/24/09

Comments:

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2579RevE		Manufactured	No			140	Each	464.0000	20.0000			
Crossbolt Spacer												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	464		
43988	4		
46434	4		
46956	2		
47797	9		
48272	22		
51314	100		
51315	323		

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2855RevA		Manufactured	No			200	Each	29.0000	1.0000			
Cap												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
FP	-1		
50513	-1		
Main Warehouse			
FP6	31		
50513	31		
Main Warehouse			
ST	-1		
50513	-1		

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

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August 25, 2009 1:34:20 PM

Work Order ID: 51510

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/24/09 **Required Date:** 8/24/09

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3-5A		Purchased	No			200	Each	2,515.000	2.0000			
Bolt												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	2515		_____
100188	212		_____
105057	2245		_____
15205	58		_____

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10L		Purchased	No			200	Each	6,679.000	2.0000			
Washer												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
FP	-2		_____
109632	-2		_____
Main Warehouse			
ST	6681		_____
101291	16		_____
104885	153		_____
105793	236		_____
109632	1276		_____
110985	5000		_____

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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Work Order ID: 51510

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/24/09 **Required Date:** 8/24/09

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS7-1032-130		Purchased	No			200	Each	3,628.000	50.0000			
Insert												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	3628		_____
105855	16		_____
108606	52		_____
111529	1560		_____
111779	2000		_____

AN3C4A		Purchased	No			200	Each	632.0000	50.0000			
BOLT												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
FP	-50		_____
112314	-50		_____
Main Warehouse			
ST	682		_____
112082	30		_____
112314	652		_____

Dart Aerospace Ltd

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Start Date: 8/24/09 **Required Date:** 8/24/09

Comments:

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L		Purchased	No			200	Each	2,946.000	50.0000			
washer												

Warehouse Location	Loc Qty	Loc Code	
OFFSHORE			
FG	100		_____
103585	100		_____
Main Warehouse			
FP	-50		_____
112116	-50		_____
Main Warehouse			
ST	2896		_____
112116	2896		_____

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3566-13RevC		Manufactured	No			200	Each	20.0000	1.0000			
Gasket												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
FP	-1		_____
48166	-1		_____
Main Warehouse			
ST	21		_____
45717	1		_____
46889	1		_____
48166	3		_____
50265	16		_____

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Replacement Skidtube

Comments:

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Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3566-5RevC		Manufactured	No			200	Each	17.0000	1.0000			
Gasket												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
FP19	-1		_____
51260	-1		_____
Main Warehouse			
ST	18		_____
36113	1		_____
46186	1		_____
47318	1		_____
48167	1		_____
51260	14		_____

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3566-1RevC		Manufactured	No			200	Each	27.0000	2.0000			
Gasket												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
FP	-2		_____
51259	-2		_____
Main Warehouse			
ST	29		_____
46349	1		_____
47434	2		_____
51218	1		_____
51259	25		_____

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

August 25, 2009 1:34:20 PM

Work Order ID: 51510

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Start Date: 8/24/09 **Required Date:** 8/24/09

Comments:

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-11RevD		Manufactured	No			200	Each	29.0000	1.0000			

Wearshoe

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
FP	22		_____
51256	22		_____
Main Warehouse			
FP19	-1		_____
50112	-1		_____
Main Warehouse			
ST	8		_____
45823	1		_____
50112	7		_____

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

August 25, 2009 1:34:20 PM

Work Order ID: 51510

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/24/09 **Required Date:** 8/24/09

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-13RevD		Manufactured	No			200	Each	30.0000	1.0000			

Wearshoe

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
FP17	17		_____
50270	17		_____
Main Warehouse			
FP19	-1		_____
50270	-1		_____
Main Warehouse			
ST	14		_____
45409	3		_____
46495	10		_____
47867	1		_____

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

August 25, 2009 1:34:20 PM

Work Order ID: 51510

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/24/09 **Required Date:** 8/24/09

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-9RevD		Manufactured	No			200	Each	20.0000	1.0000			
Wearshoe												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
FP19	-2		
51258	-2		
Main Warehouse			
ST	22		
44659	1		
45825	1		
51258	20		

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-5RevD		Manufactured	No			200	Each	17.0000	1.0000			
Wearshoe												

Warehouse Location	Loc Qty	Loc Code	
OFFSHORE			
FG	2		
34806	2		
Main Warehouse			
FP19	15		
48555	1		
51257	14		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

August 25, 2009 1:34:20 PM

Work Order ID: 51510

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 8/24/09 **Required Date:** 8/24/09

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2594-3RevC		Manufactured	No			200	Each	542.0000	16.0000			
O-Ring, 205 Skidtube												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	542		_____
27168	44		_____
29908	498		_____

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2594-1RevC		Manufactured	No			200	Each	348.0000	16.0000			
Plug, 205 Skidtube												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	348		_____
42221	16		_____
42807	92		_____
43884	3		_____
46435	2		_____
47251	235		_____

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

5/5/10

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS

RELEASED
07.06.28

A	96.09.16	NEW ISSUE
B	96.12.02	AS MANUFACTURED
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183

QTY -041	QTY -045	Part Number	Description
X		**D2580-041**	**SKIDTUBE ASSEMBLY**
	X	**D2580-045**	**SKIDTUBE ASSEMBLY**
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

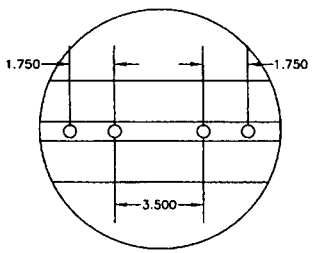
GENERAL NOTES:

1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
2) ALL DIMENSIONS ARE IN INCHES
3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL ∅0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
6) WELDING TO BE DONE PER DART QSI 004.
7) FINISH:
 SEE NOTES ON
 PAGE 2 FOR D2580-041 AND
 PAGE 3 FOR D2580-045
8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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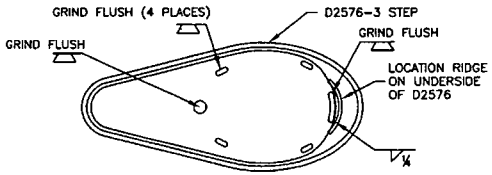
w/o 51510

DETAIL A
SCALE 5:24

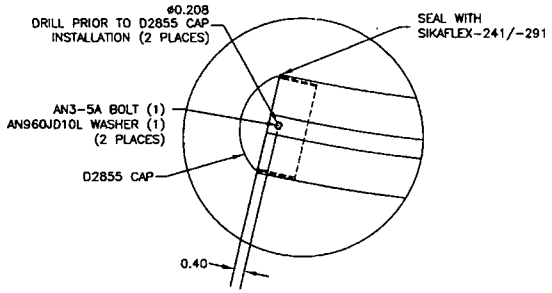


RELEASED
07 de 28

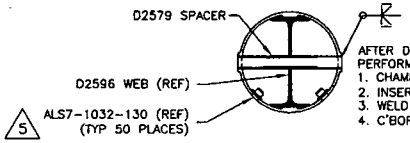
DETAIL B
SCALE 5:24



DETAIL C
SCALE 5:24

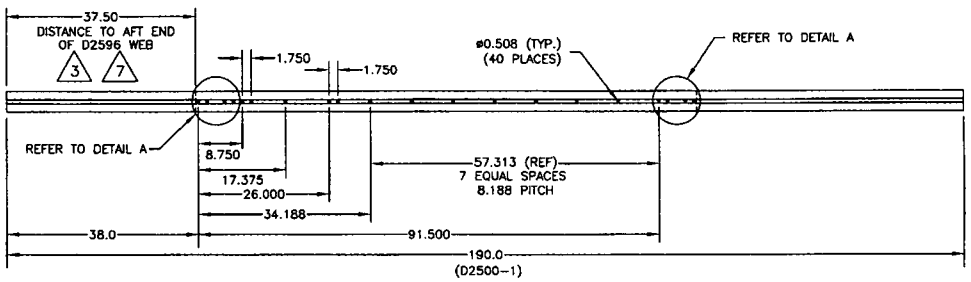


SECTION D-D
SCALE 5:24

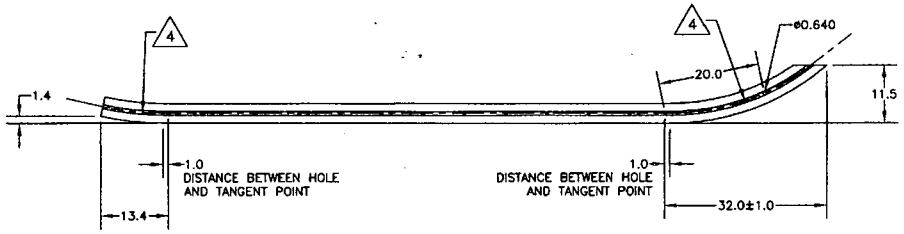


AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO ø0.437 X 1.00 DEEP

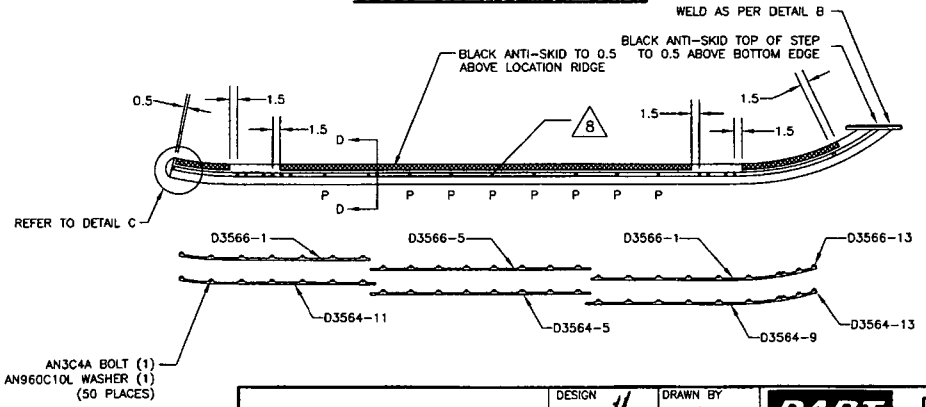
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL



D2580-041 NOTES

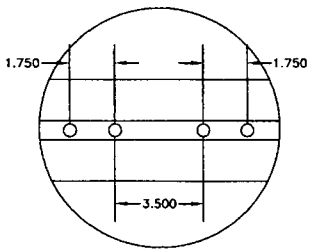
i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2580 REV. D
DATE 07.02.27		SHEET 2 OF 3
		TITLE 205 SKIDTUBE ASSEMBLY SCALE 1:24

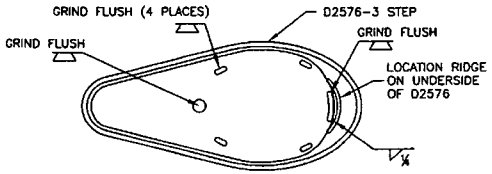
W/O 51510

DETAIL E
SCALE 5:24

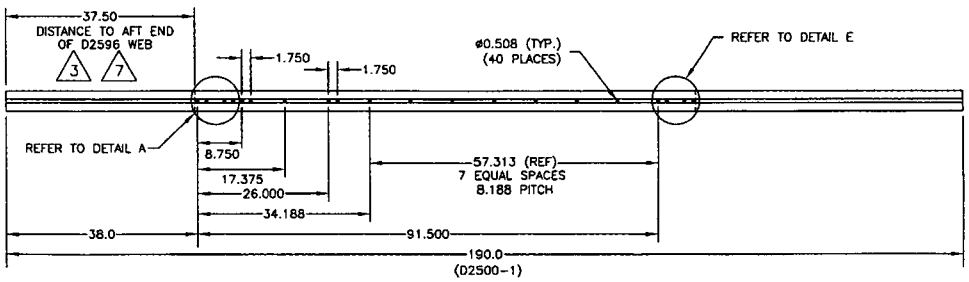


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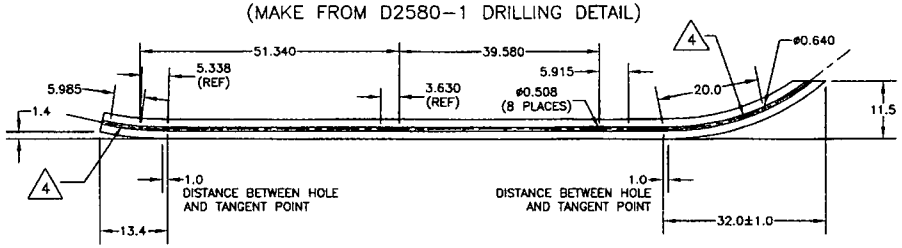
DETAIL F
SCALE 5:24



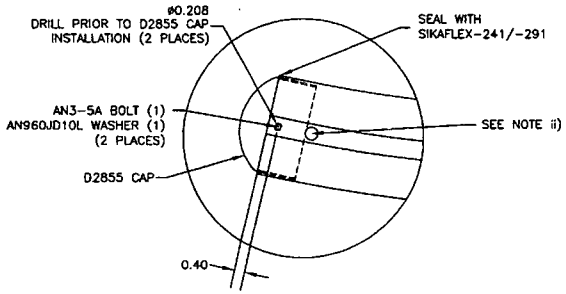
D2580-1 DRILLING DETAIL



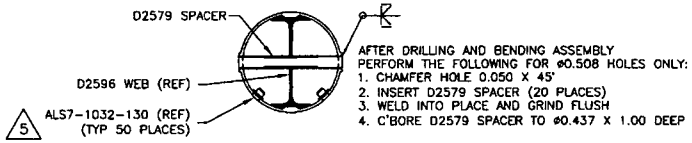
D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



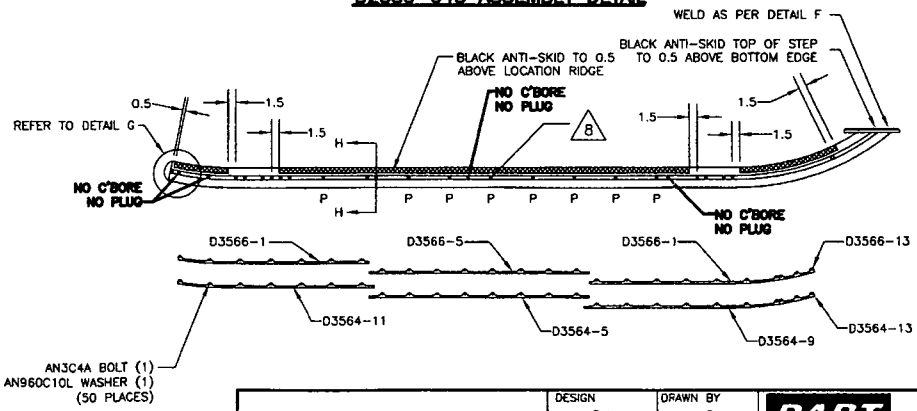
DETAIL G
SCALE 5:24



SECTION H-H
SCALE 5:24



D2580-045 ASSEMBLY DETAIL



C

D2580-045 NOTES

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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RH	RH	
CHECKED	APPROVED	DRAWING NO. D2580 REV. D
		SHEET 3 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY SCALE 1:24